

June 11

Work Order ID 83727

\*83727\*

Page 1

April-24-12 1:24:10 PM

Item ID: D350-591-311

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/24

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

110

0.00

\*110\*

Large Fab

Large Fab

0.00

Memo

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod M119785

3-Grind End Plate flush M120854

12.05.10  
Ae

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Start Date: 24/04/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*120\***

QC Memo 0.00

Quality Control

*\* 10 0 BE 12/05/10*

130 QC5- Inspect part completeness to step on W/O 0.00

**\*130\***

QC Memo 0.00

Quality Control

*(10) 12-05-10*

140 Chemical Conversion Coat per QSI005 4.1 0.00

**\*140\***

HandFinish Memo 0.00

Hand Finishing

*(10) 12-5-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-591-311

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**\*N900040100\***

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Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>						10	0		pl 12.05.15
QC	Memo	0.00							
Quality Control									
180		0.00							
<b>*180*</b>	Large Fab					10	0		pl 12.05.15
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI004 & Dwg D3272								
	A/RAluminum Rod 11978								
	6-Grind End Plate flush 120854								
	7-Install last rivet as per Dwg.								

12.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop **\*NS2\***

Start Date: 24/04/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

**\*190\***

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

10 26 12517

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 08/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*220*</b> Powdercoat Powder Coating	Memo START TIME: 10:45 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:15	0.00				10 X	0		MJ 12/25/22
230	Wing Walk as per dwg QSI005 4.4 Batch	12/505 0.00							
<b>*230*</b> HandFinish Hand Finishing	Memo	0.00				10	0		12-5-22
240	QC3- Inspect Part Finish	0.00							
<b>*240*</b> QC Quality Control	Memo	0.00				10			12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00				10x			SP 12-5-23
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00				10			NW 12 05-23
Quality Control									
270		0.00							
<b>*270*</b>									
Packaging	Packaging	0.00							
Packaging	Memo	0.00				10x			SP 12-5-23
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: _____								

Rev D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12/15/25 9/27  
MCS 12/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 83727

**\*83727\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified  
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	20.0000	1	10			
<b>*D3272-1*</b>									<b>**</b>				
Step													

Location	Loc Qty	Loc Code
ST	-10	
WA	30	
81312	10	
81313	10	

D3067-1		Manufactured	No			110	Each	187.0000	1	10			
<b>*D3067-1*</b>									<b>**</b>				
End Plate													

Location	Loc Qty	Loc Code
WA	123	
78608	4	
80881	45	
81969	74	
WA016	64	
67582	2	
68214	1	
79607	1	
83053	60	

12.05.02

10

12.05.10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-311

\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No

110 Each 323.0000 2 20

\*D3219-1\*

Plate

\*\*

12.05.10

Location	Loc Qty	Loc Code
WA 381292	84	
82221	84	
WA016	118	
73410	12	
77674	6	
81292	80	
82059	20	
WA017	121	
81971	121	

20

D3066-1 Manufactured No

180 Each 101.0000 2 20

\*D3066-1\*

Spacer

\*\*

383854 (9) Ae 12.05.14

Location	Loc Qty	Loc Code
WA	101	
81968	101	

11

MS20600-AD4W4 Purchased No

180 Each 3,044.000 16 160

\*MS20600-AD4W4\*

Rivets

\*\*

3118840 (160) Ae 12.05.14

Location	Loc Qty	Loc Code
ST321	3044	
121011	9	
121340	1035	
121444	2000	

April-24-12 1:24:14 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

19.0000

1

10

**\*D3065-041\***

Step Leg Assembly Hi

\*\*

B 83368 (10) Ae  
12.05.14

Location

Loc Qty

Loc Code

WA

19

66149

0

78798

18

79336

1

D3067-1

Manufactured No

180

Each

187.0000

1

10

**\*D3067-1\***

End Plate

\*\*

12.05.15

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

AN3-35A

Purchased

No

250

Each

147.0000

2

20

**\*AN3-35A\***

Bolt

\*\*

SP 12-5-23

Location

Loc Qty

Loc Code

ST353

147

120644

50

120717

50

121068

47

20X - 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-311

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3235-1  
\*D3235-1\*  
Mounting Lug

Manufactured No

250 Each

69.0000

2

20

\*\*

B81970 SP.

Location

Loc Qty

Loc Code

ST

69

78787

69

Manufactured No

250 Each

83.0000

1

10

\*\*

SP.

D3278-041  
\*D3278-041\*  
Support Assembly

Location

Loc Qty

Loc Code

ST471

3

78795

3

ST481

80

82015

40

83361

40

10x

AN960JD416  
\*AN960JD416\*  
Washer

NAS1149D0463J Purchased

No

250 Each

10.0000

16

160

\*\*

M/21708 SP.

Location

Loc Qty

Loc Code

ST351

10

116289

10

Manufactured No

250 Each

0.0000

4

40

\*\*

M/19546 SP.

AN960JD516  
\*AN960JD516\*  
Washer

NAS1149D0563J Purchased

No

12-5-23.

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Shop Packet Print

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN5-36A  
**\*AN5-36A\***  
Bolt

Purchased No

250 Each

186.0000

2 20

\*\*

Location

Loc Qty

Loc Code

340

100

121181

100

ST340

86

120187

36

120731

50

20x S C

D2618  
**\*D2618\***  
Bushing

Manufactured No

250 Each

220.0000

2 20

\*\*

Location

Loc Qty

Loc Code

ST012

220

76130

2

78537

18

80474

200

20x S C

D2230-3  
**\*D2230-3\***  
Lug

Manufactured No

250 Each

147.0000

4 40

\*\*

Location

Loc Qty

Loc Code

ST480

147

53881

4

70973

1

81558

142

B81962 SP  
S C 12-5-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-24-12 1:24:14 PM

Page 6

Work Order ID: 83727

**\*83727\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

353.5345

1.2

12

**\*D2856-400\***

Abrasion Strip

\*\*

SP

Location

Loc Qty

Loc Code

ST403

216

81875

216

ST409

137.5345

63735

0.6696

68076

0.3149

71164

8.46

79551

128.09

12

S

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

MS21042L3

Purchased

No

250

Each

3,512.000

2

20

**\*MS21042L3\***

Nut

\*\*

SP

Location

Loc Qty

Loc Code

ST300

3512

117441

16

117885

32

118451

5

118927

3

119017

1384

119075

158

121349

914

1214444

1000

20X

S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-24-12 1:24:14 PM

Page 7

Work Order ID: 83727

\*83727\*

Parent Item: D350-591-311

\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A  
\*AN4-13A\*  
Bolt

Purchased No 250 Each 1,099.000 8 80

\*\*

Location	Loc Qty	Loc Code
ST357	1099	
119449	39	
120187	19	
120422	141	
120770	400	
121162	500	

MS21042L5  
\*MS21042L5\*  
Nut

Purchased No 250 Each 1,337.000 2 20

\*\*

Location	Loc Qty	Loc Code
ST300	1337	
116105	5	
116548	43	
117611	30	
119109	1259	

MS21042L4  
\*MS21042L4\*  
Nut

Purchased No 250 Each 6,002.000 8 80

\*\*

Location	Loc Qty	Loc Code
ST300	6002	
116188	5	
119017	4	
119075	993	
121011	2000	
121444	3000	

AN960JD10  
\*AN960JD10\*  
Washer

NAS1149D0363J Purchased No

250 Each 0.0000 4 40

\*\*

April-24-12 1:24:14 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>js</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>js</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83723-ML5  
12/04/24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

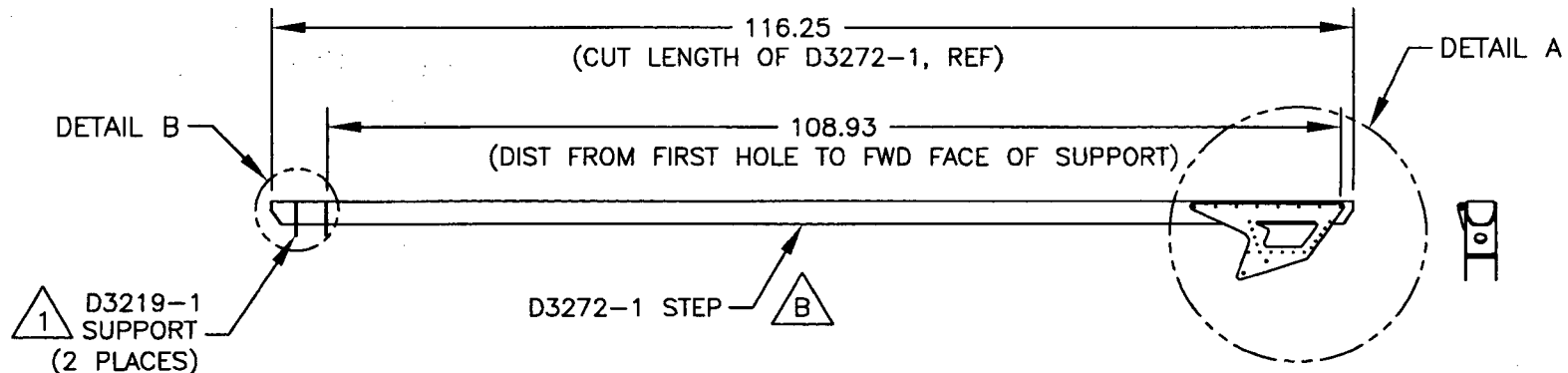
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

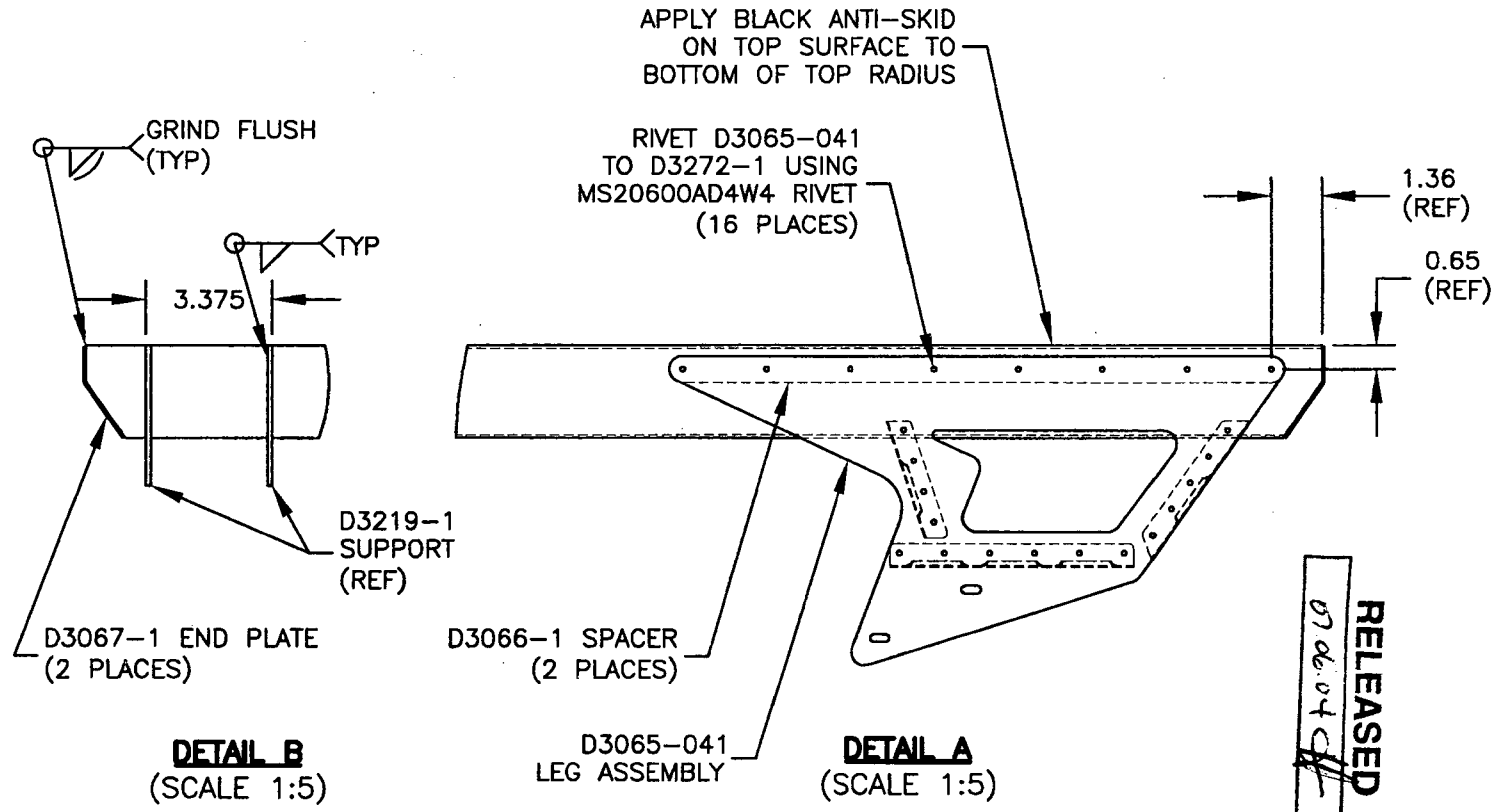
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

83727



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



DESIGN	40	DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED		REV. B
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3
			STEP ASSEMBLY, HI LONG	SCALE 1:20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



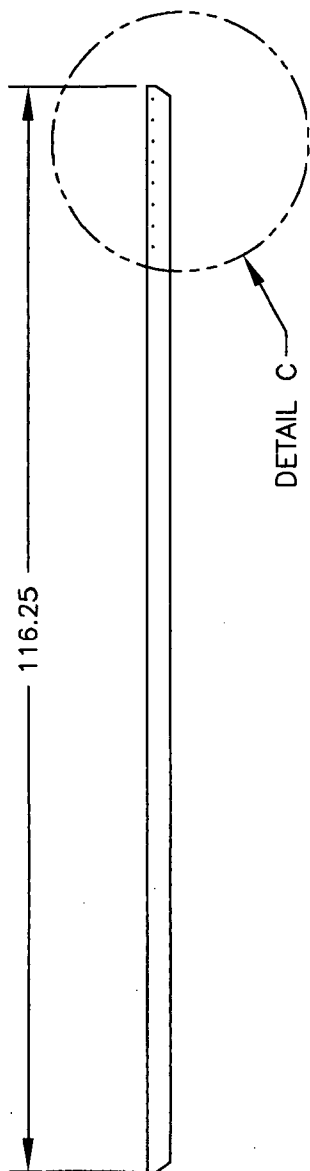
83727



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

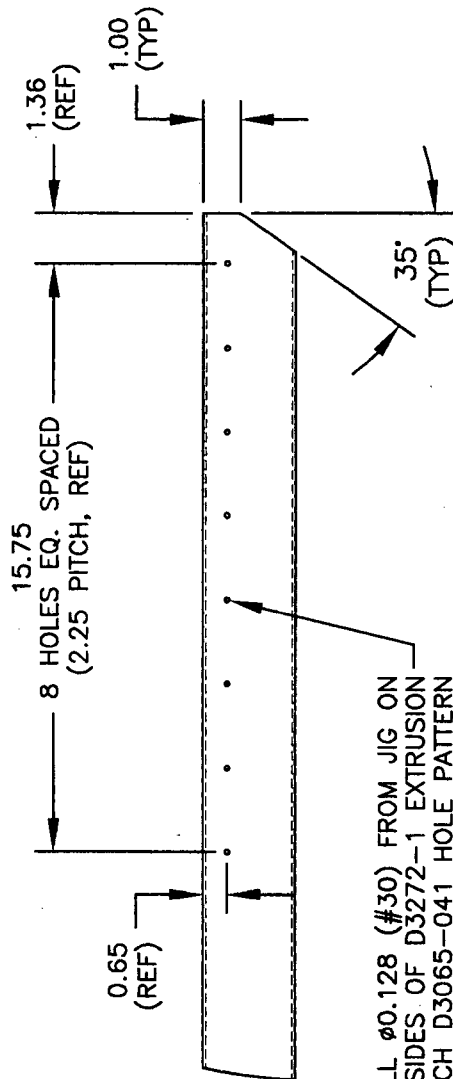
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
	X							D350-591-212	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
		X						D350-591-213	<b>Heli-Access-Step™</b> , Short Step – High Skid, LH
			X					D350-591-214	<b>Heli-Access-Step™</b> , Short Step – High Skid, RH
				X				D350-591-215	<b>Heli-Access-Step™</b> , Short Step – Low Skid, LH
					X			D350-591-216	<b>Heli-Access-Step™</b> , Short Step – Low Skid, RH
						X		D350-591-311	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
							X	D350-591-312	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

# Work Order ID 83727

April-24-12 1:24:10 PM

\*83727\*

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Acc<sup>ss</sup>-Step, Long LH

Start Date: 24/04/2012 Start Qty: 10.00

Required Date: 08/05/2012 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *ML5*

QC:

Date: *12/04/24* Tooling:  
Date: SPC (Y/N):

\*N9000040100\*

Cust Item ID:  
Customer:

Setup Start \*NS1\*

Stop \*NS2\*

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	DOCUMENT CONTROL	0.00							
*100*		0.00							
DC	Memo								
Document Control	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								
110		0.00							
*110*	Large Fab	0.00							
Large Fab	Memo								
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg								
	D3272								
	A/RAluminum Rod <i>m119785</i>								
	<i>m120854</i>								
	3-Grind End Plate flush								

*ML5 12/05/23*  
*10*

*10* *12.05.10*

*Ae*  
*12.05.10*